Claims

1.

| 1 | Amethod of forming a cap for a container, comprising the steps of: |
|---|--|
| 2 | molding a polymeric container to form the container and a flash section |
| 3 | integral with the container; |
| 4 | forming at least one cap in the flash section; and |
| 5 | separating the cap from the flash section to form a separate cap. |
| | |
| 1 | The method of claim 1 wherein the molding step comprises blow molding |
| 2 | the container within a mold die having two mold halves with the flash section defined at |
| 3 | least in part between the mold halves. |
| | 3. |
| 1 | The method of claim 2 wherein at least one of the halves has a projection |
| 2 | adapted to provide a recess in the flash section with the recess defining a portion of the |
| 3 | cap when it is separated from the flash section. |
| | 4. |
| 1 | The method of claim wherein the container and flash section are formed |
| 2 | from multiple layers of material |

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The method of claim 1 wherein the container and cap have a vapor barrier 1 2 layer disposed between inner and outer layers of a different material. 6. A fuel tank, comprising: a tank wall formed from multiple layers of polymeric material including at least one structural layer and at least one vapor barrier layer, at least one flash section to be removed from the tank wall, and an opening through the tank wall; and a cap formed from the material of said at/least one flash section fixed to the tank wall to cover the opening. The fuel tank of claim 6/wherein the tank wall and the cap each have an 1 inner layer, an outer layer and a vapor barrier layer disposed between the inner and outer 2 3 layers. 8.

layers of the cap are/weldable to permit the cap to be welded to the tank wall.

The fuel tank of claim 7 wherein at least one of the inner layer and outer

| | 1 | The fuel tank of claim 8 wherein the inner layer and outer layer are formed |
|----|-----|--|
| | 2 | from a polyethylene. |
| | | |
| | | 10. |
| | | |
| | 1 | A method of forming a container and cap, comprising the steps of: |
| 13 | 2 | providing a parison within a pair of open mold halves each defining in part |
| J | 3 . | a mold cavity; |
| | 4 | closing the mold halves together; |
| IJ | 5 | providing a pressurized fluid into the parison within the closed mold halves |
| | 6 | to expand the parison within the mold cavity and to form and define the shape of the |
| | 7 | container; |
| = | 8 | forming at least one flash section between the mold halves; |
| | 9 | forming at least one cap in the flash section; and |
| 1 | 0 | separating the cap from the flash section. |
| | | |
| | | 11. |
| | 1 | The method of claim 10 which also comprises the step of providing an |
| | 2 | opening in the container and sealing the cap to the container to close the opening. |
| | | |

The method of claim 11 wherein the cap is welded to the tank. 1 13. 1 The method of claim 10 wherein the flash sections and the container are 2 formed simultaneously 14. A cap for a polymeric fuel tank, comprising: 2 a body formed from at least one layer of a polymeric material suitable for attachment in sealed relationship to the fuel tank and two vapor barrier layers constructed to at least restrict the permeation of fuel vapor therethrough. 15. The cap of claim 14 wherein the body has at least two layers of polymeric 1 material with the vapor barrier layers disposed between them. 2 16. The cap of claim 14 wherein each vapor barrier layer is disposed between 1 a pair of layer's of polymeric material with at least one layer of polymeric material 2

disposed between the vapor barrier layers.

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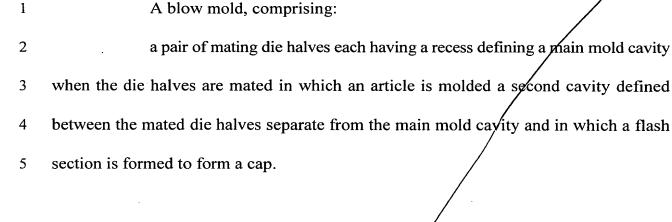
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18.

The blow mold of claim 17 wherein the second cavity is defined by cooperating recesses formed in each die half.

19.

The blow mold of claim 18 wherein an annular recess is defined in one die half and a generally circular recess is defined in the other die half.

20.

The blow/mold of claim 18 wherein a generally circular recess is defined in each die half.

21.

The blow mold of claim 17 wherein the second cavity is defined in a gap between the die halves.

The blow mold of claim 21 which also comprises a projection carried by

2 one die half extending into the second cavity to define a recess in the flash.